

Work Order ID 79076-1

January-19-12 1:40:01 PM

Split 2

\*79076\*

Page 1

Item ID: D3560-041

Accept

Revision ID:

\*N9000040100\*

Setup Start \*NS1\*

Item Name: Arm Weldment

Stop \*NS2\*

Start Date: 19/01/2012 Start Qty: 4.00 <sup>10.0</sup> \*4\*

Required Date: 02/02/2012 Req'd Qty: 4.00 \*4\*

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan: MCT

Date: 12/01/19

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3560	Rev D

100

\*100\*

Bandsaw

BAND SAW

0.00

Jeaspa Bandsaw

Memo

0.00

Cut blanks 16.750" long

cut 12/01/26

10

0

110

\*110\*

HAAS I

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS CNC vertical machine #1

Memo

0.00

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D  
2-C'sink 0.196" hole on manual mill as per dwg D3560  
3-Deburr per dwg D3560

10

0

B. J. 12/01/29

120

\*120\*

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

10

0

B. J. 12/01/29

Work Order ID 79076

\*79076\*

Page 2

January-19-12 1:40:01 PM

Item ID: D3560-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Arm Weldment

Stop \*NS2\*

Start Date: 19/01/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

\*140\*

Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad )

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch ( 65 deg C )

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

Alum. Rod # B119712

# Work Order ID 79076

January-19-12 1:40:01 PM

**\*79076\***

Page 3

Item ID: D3560-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Arm Weldment

Stop

**\*NS2\***

Start Date: 19/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

51210214

XL  
-011

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control

1 0 BE12-02-01

170

Chemical Conversion Coat per QSI005 4.1

0.00

**\*170\***

HandFinish

Memo

0.00

Hand Finishing

12-02-01

1 0

# Work Order ID 79076

January-19-12 1:40:01 PM

**\*79076\***

Page 4

Item ID: D3560-041

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Arm Weldment

Stop **\*NS2\***

Start Date: 19/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

~~QC3~~ Inspect Part Finish

0.00

**\*180\***

*QC7*

QC

Memo

0.00

Quality Control

*1 BR 12-2-1*

190

Small Fab

0.00

**\*190\***

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

*EP 12/02/01 (1)*

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

*5762101*

*(41)*

*041*



# Picklist Print

January-19-12 1:40:04 PM

Page 1

Work Order ID: 79076

Parent Item: D3560-041

Parent Item Name: Arm Weldment

\*79076\*

\*D3560-041\*

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC  
IPP rev B ECN 987 07.10.09 EC verified by: DD  
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808		Manufactured	No			100	Each	22.0000	1	4			
*D2808*									**				
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				22					
				32896				2					
				71879				8					
				76188				12					
M6061T6B0.500X05.00		Purchased	No			140	f	59.7480	1.395	5.873684			
0													

\*M6061T6B0 500X05 000\*

6061-T6 Bar .500 x 5.00

\*\*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT001	35.748	
112154	6.935	
117933	4.813	
119324	24	
MAT004	24	
120243	24	

M120421 x 14.69 and 12/01/26

# Picklist Print

January-19-12 1:40:04 PM

Page 2

Work Order ID: 79076

Parent Item: D3560-041

Parent Item Name: Arm Weldment

\*79076\*

\*D3560-041\*

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3592-1

Manufactured No

190

Each

15.0000

1

4

\*\*

*12.01.13*

\*D3592-1\*

Plate

Location

Loc Qty

Loc Code

WA

6

78934

6

WA002

9

47015

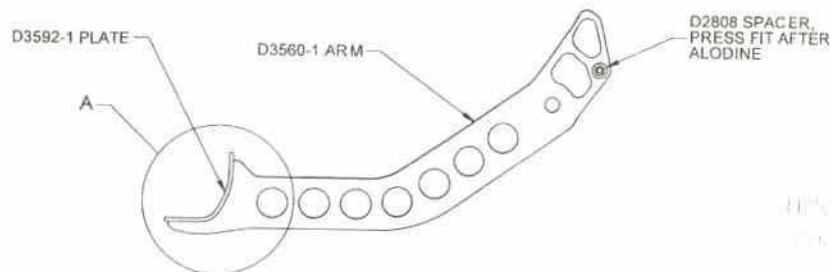
2

48517

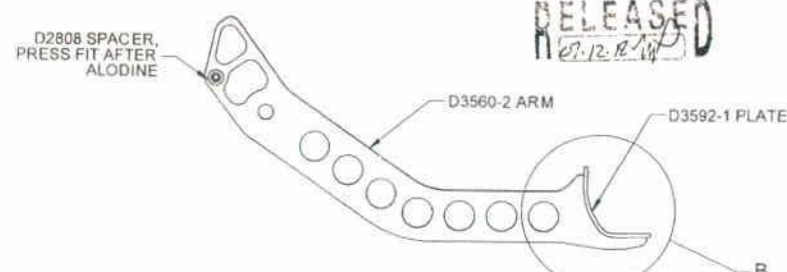
7

*1*

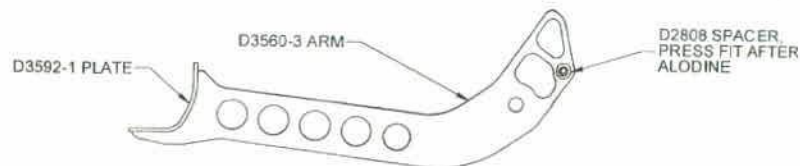
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07-12-2016



**D3560-041 ARM WELDMENT**



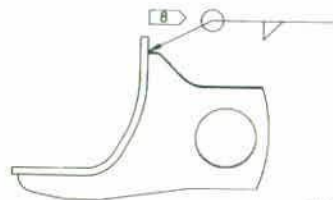
**D3560-042 ARM WELDMENT**



**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**



**DETAIL A  
SCALE 1:2**

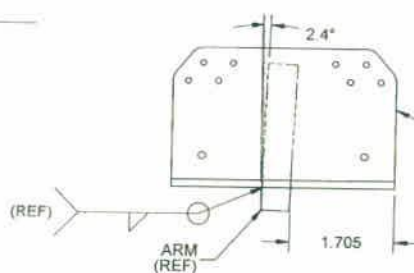
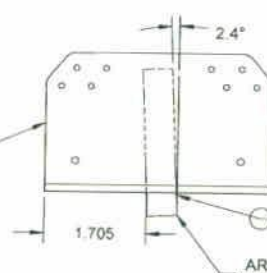
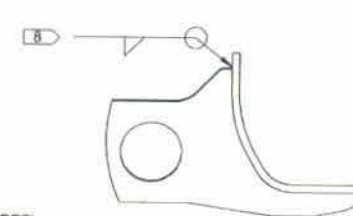


PLATE  
(REF)



ARM  
(REF)



**DETAIL B  
SCALE 1:2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.23 lbs (TYP)  
 8) WELDING: PER DART QSI 004

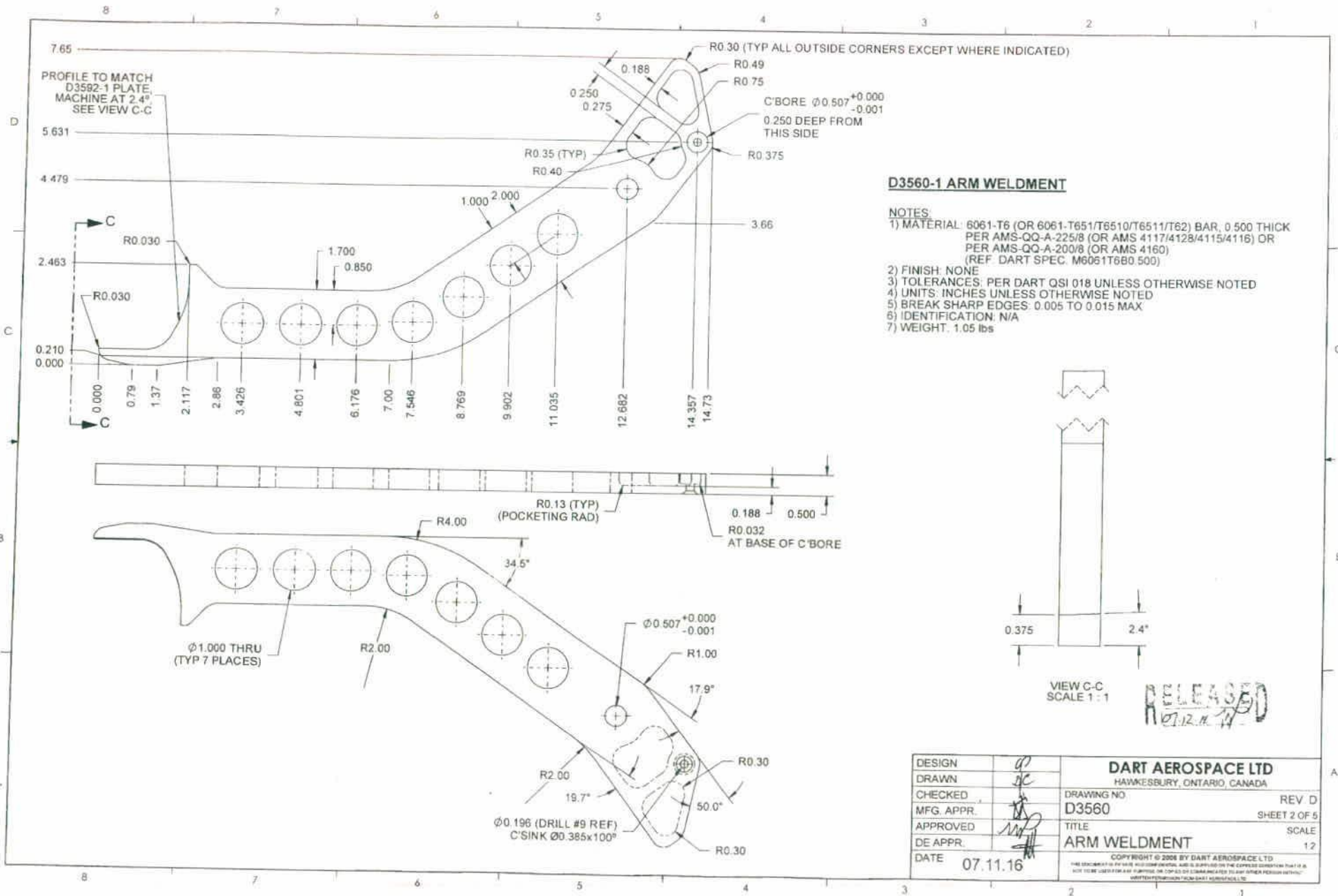
D	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
 TITLE **ARM WELDMENT** SCALE 1:4  
 SHEET 1 OF 5

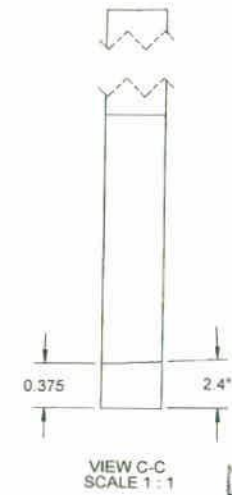
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79076



# D3560-1 ARM WELDMENT

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC. M6061T680.500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs



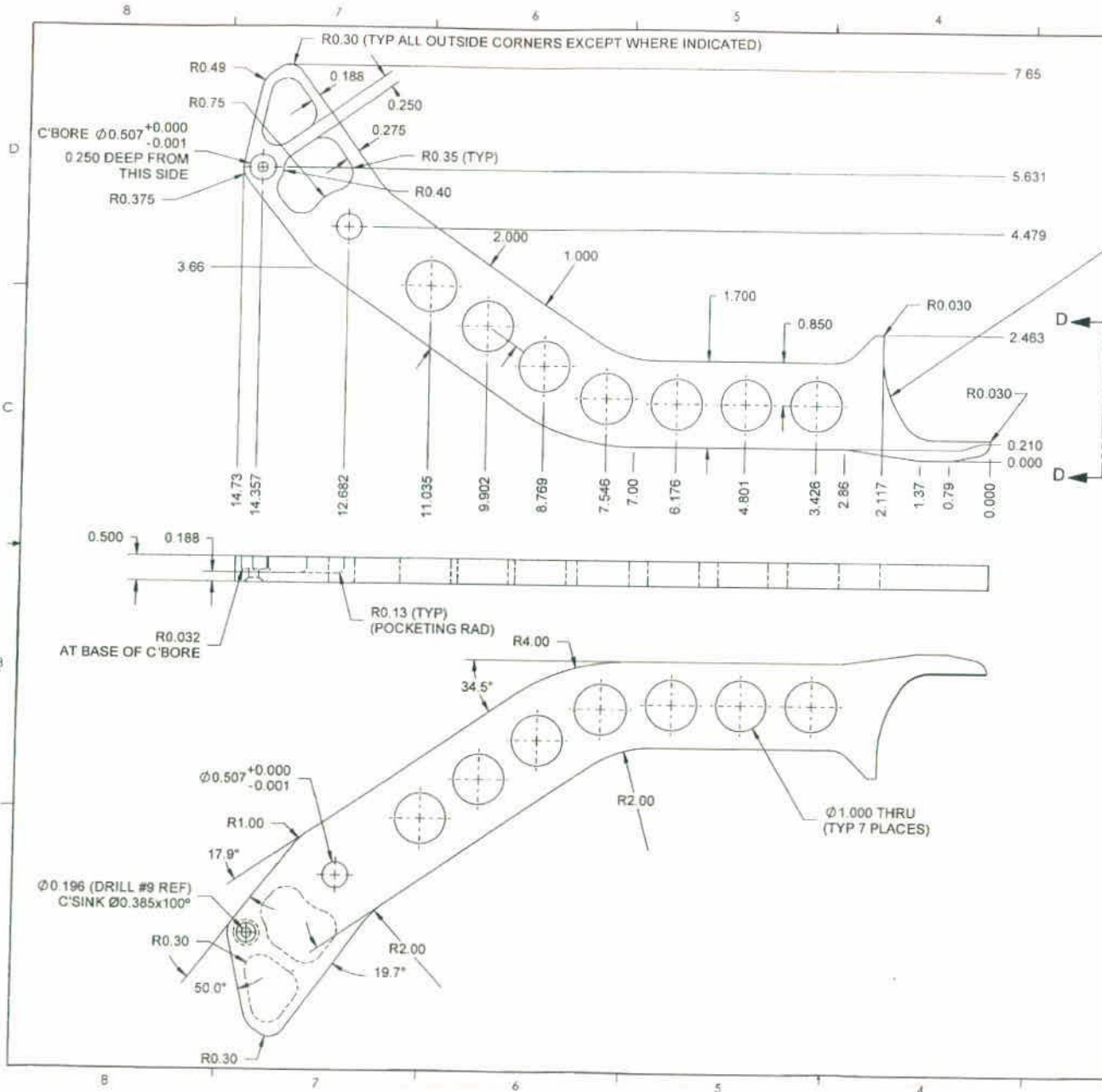
VIEW C-C  
SCALE 1:1

RELEASED  
07.12.16

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV D
MFG. APPR.		D3560	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	12
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	



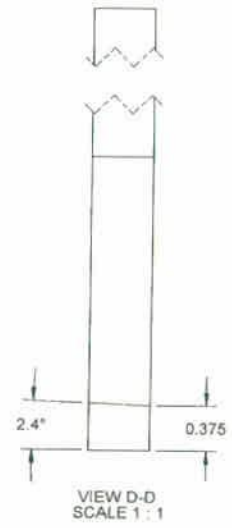
79076



PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4°  
SEE VIEW D-D

### D3560-2 ARM

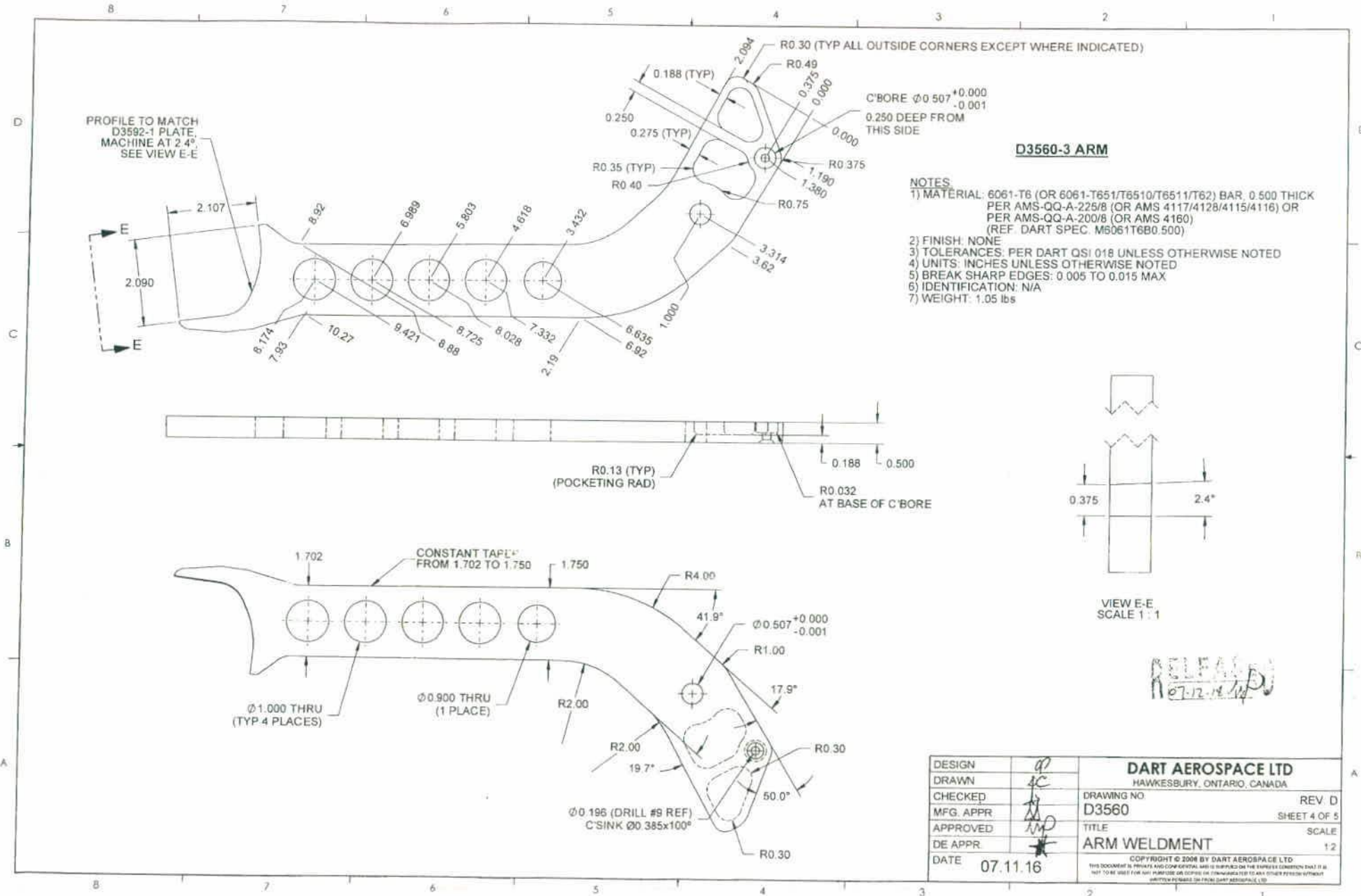
- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B0 500)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.05 lbs

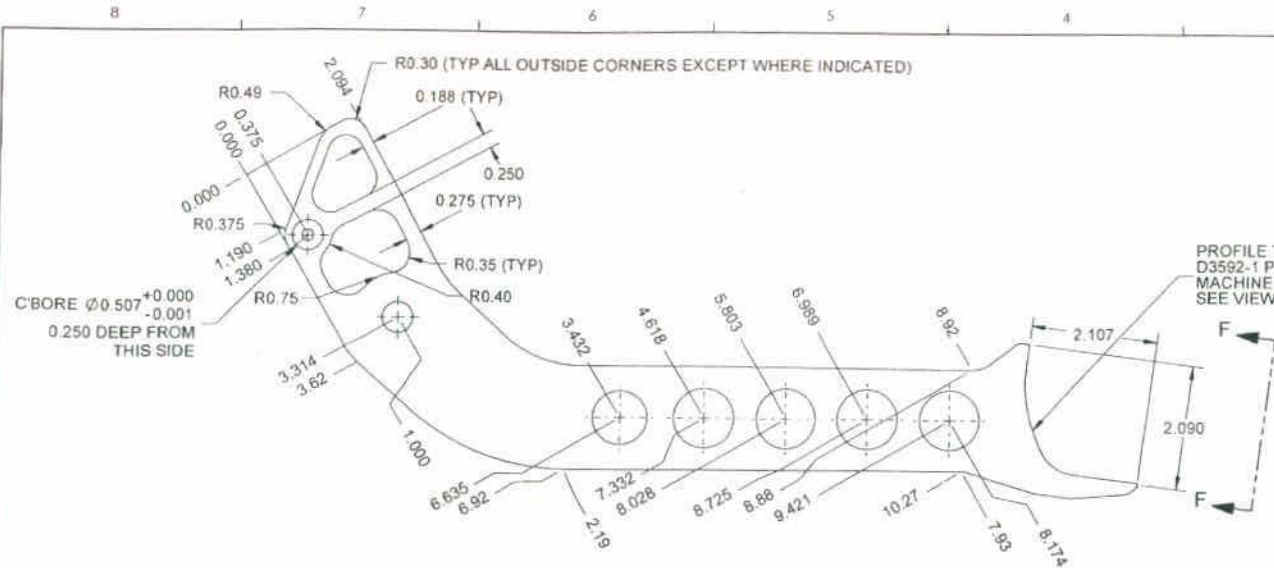


DESIGN	g	<b>DART AEROSPACE LTD</b>	
DRAWN	jc	HAWKESBURY, ONTARIO, CANADA	
CHECKED	g	DRAWING NO.	REV. D
MFG APPR	g	D3560	SHEET 3 OF 5
APPROVED	g	TITLE	SCALE
DE APPR	g	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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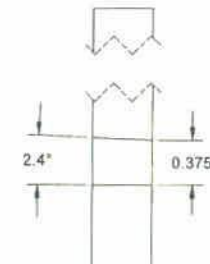
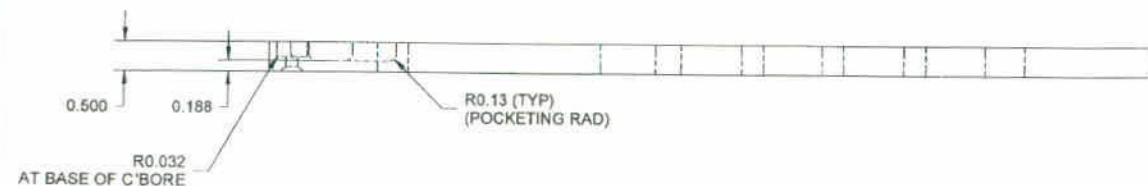




**D3560-4 ARM**

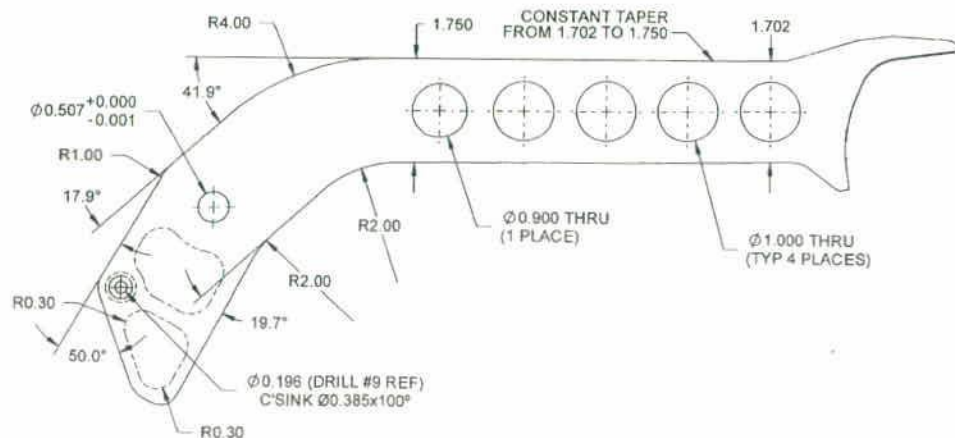
## NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M9061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW F-F  
SCALE 1 : 1

107.12.44P



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV D
MFG APPR		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
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DART AEROSPACE LTD		Work Order: 79076
Description: ARM weldment		Part Number: D3560-1
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.000	+0.010 / - .001	Ø 1.003	✓		SL02 Mic.	
Ø 0.507	+0.004 / - .001	Ø 0.5068	✓		"	
Ø .507 x .250 max	+0.000 / - .001	Ø .5065 x .252	✓		"	
.188 <sup>height</sup> <sub>depth</sub>	+/- .010	0.187	✓		SL08 Vern	
.188	+/- .010	0.190	✓		"	
.250	+/- .010	0.250	✓		"	
.275	+/- .010	0.278	✓		"	
2.000	+/- .010	2.003	✓		"	
1.000	+/- .010	1.005	✓		"	
1.700	+/- .010	1.704	✓		"	
.850	+/- .010	0.851	✓		"	
Ø .196	+0.005 / - .001	Ø .196	✓		"	
1.375	+/- .010	1.371	✓		"	
2.463	+/- .010	2.466	✓		Height gauge	
.210	+/- .010	0.210	✓		"	
Ø 0.385 x 100°	+/- .010 x .5°	Ø 0.385	✓		SL08	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval: _____
Date: 12/01/29	Date: 12-1-30	Date: _____

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Handwritten signature]* 10-28-15